

5047998



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D6201**Job Sheet 173203****Part No:** D6201**Job Qty:** 20 ft**Part Name:** T Extrusion**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/27/18**Job Tracking No:****Due Date:** 3/7/18**Created By:** Chantal Lavoie**Type:** Stock**Description:****Note:** DWG REV A

FEB 27 2018

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Receive Ft	20 ft	3/7/18	3/7/18	0.00	0.00	Purchasing		MAR 5 2018
110	Packaging	20 pcs	3/7/18	3/7/18	0.00	0.00	Packaging2		MAR 5 2018
120	QC	20 pcs	3/7/18	3/7/18	0.00	0.00	QC6		MAR 5 2018
130	Packaging	20 pcs	3/7/18	3/7/18	0.00	0.00	Packaging3-2		MAR 5 2018
140	QC21-SA FT	20 ft	3/7/18	3/7/18	0.00	0.00	QC21		MAR 7 2018

Part Op 100 - Issue P/O: 39137 a) Description: T-beam extrusion b) 4.00" x 4.00" x 0.375" c) Minimum Ultimate Tensile
Descriptions: Strength = 38ksi d) Minimum Yield Tensile strength = 35ksi e) Material: 6061-T6/T6511 (QQ-A-200/8)

110 - Ensure material certification is attached

120 - Ensure Material certification comply to Dwg D6201

130 - LOCATION: MAT028

CL 18/02/27 x 20ft.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201P	T Extrusion 4X4X3/8	20 ft (1 ea)	100-Receive Ft	

Job Allocations

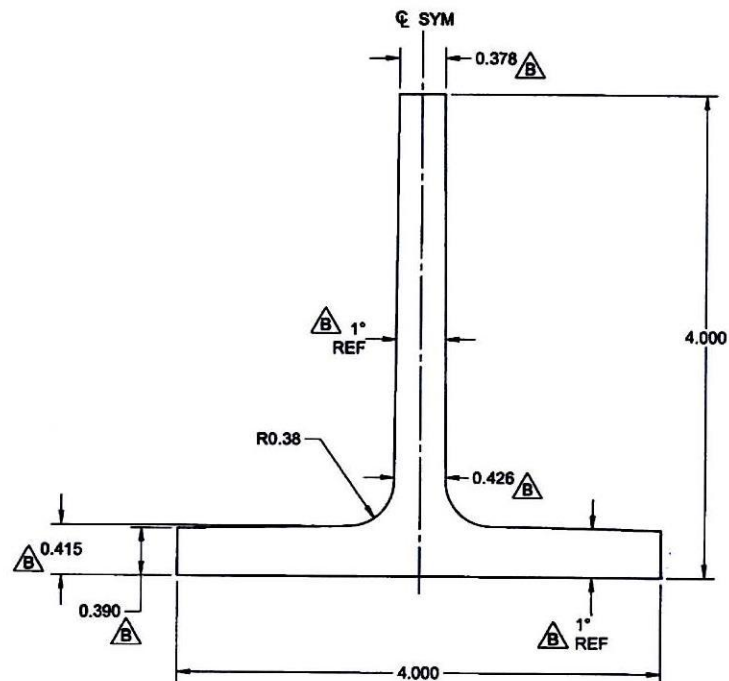
Operation	Component Part	Required	Inventory	Allocated
100-Receive Ft	D6201P	20	0	0

Part Specifications

Specifications could not be found.

Plex 2/27/18 8:25 AM dart.lavoie.chantal

SPECIFICATION CONTROL DRAWING



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES
EG. 27 INCHES LONG EXTRUSION: D6201-027

NOTES:

- 1) MATERIAL: ALUMINUM T-EXTRUSION, ROUND FILLET
6061-T6/T6511 PER AMS-QQ-A-200/8 OR QQ-A-200/8 OR ASTM B221
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.67 lb/ft

RELEASED
2017-07-27
ECN 17-660

B	REFORMAT TO CURRENT STANDARDS: 1° TAPERS DEFINED BY 0.378 & 0.428 AND 0.390 & 0.415 WERE NON-TAPERS (0.375). REASON: CAR17-184. UPDATE MATERIAL CALLOUT.	ML	17.06.05
A	NEW ISSUE	CP	01.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	ML		
CHECKED	AJS		
MFG. APPR.	LL		
APPROVED	WM		
DE APPR.	CP		
DATE	17.06.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D6201** REV. B
SHEET 1 OF 1
SCALE
T-BEAM EXTRUSION NTS

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APPROVED

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 06201P
DATE: MAR 05 2018

PO / BATCH NO.: 039137/5047940
5047998

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 20
QUANTITY INSPECTED: 20
QUANTITY REJECTED: 0

THICKNESS ORDERED: 3/8
THICKNESS RECEIVED: 3/8
SHEET SIZE ORDERED: N/A
SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒ N	
CORRECT FINISH	☒ Y	N	
CORROSION	Y	☒ N	
CORRECT GRAIN DIRECTION	☒ Y	N	
CORRECT MATERIAL PER M-DRAWING	☒ Y	N	Astm B221
CORRECT THICKNESS	☒ Y	N	
PHOTO REQUIRED	Y	☒ N	
CORRECT REF # TO LINK CERT	☒ Y	N	Heat # 852198
CORRECT MATERIAL IDENTIFICATION	☒ Y	N	
CORRECT M# ON THE MATERIAL	☒ Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u> <u>11</u>		SIGNED OFF BY: _____	
DATE: <u>9-8</u> <u>MAR 05 2018</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

75960

DART

PO.13904

C129820



SIGNATURE ALUMINUM CANADA
1860 CLEMENTS RD
PICKERING, ON L1W 3R8

CERTIFICATE OF COMPLIANCE

05/31/2015	5357009	118419	1
PO37565	020743	852188 <i>samples</i>	05/31/15

42081 A S A ALLOYS INC. 81 STEINWAY BOULEVARD ETOBICOKE, ON M9W 6H6 CANADA		42081 A S A ALLOYS INC. 81 STEINWAY BOULEVARD ETOBICOKE, ON M9W 6H6 CANADA	
002	C-031522-10	240" MILL 8061 T6511	3/8X4X4" TEE ALUMINUM
774 LBS			
752 LBS		11 PCS	1 PKGS
ASTM B221-08			

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
<u>MPA / KSI</u>	<u>MPA / KSI</u>			
334.5 / 48.5	304.2 / 44.1	15.4	N/A	92

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.60	0.24	0.19	0.06	0.87	0.06	0.06	0.02	0.01	0.00

This Material is Made in Canada
This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealuminum.com